

Date: Wednesday, 27/08/2008 11:24:51 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEAM ASSEMBLY
Job Number	: 41631		
Estimate Number	: 10407		
P.O. Number	:	Part Number	: D3173041
This Issue	: 27/08/2008 S.O. No. :	Drawing Number	: D3173 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 41268	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A 02.12.05 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6TR40X20W125	6061-T6 Rect Tube 4.0 x 2.0 x .125w
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Comment: Qty.: 4.9219 f(s)/Unit Total : 19.6875 f(s)

6061-T6 Rect Tube W.125

Material: 6061-T6 (QQ-A-200/8) Rect. Tube 4" x 2" x 0.125 thick
(M6061T6TR4.0x2.0W125)

Batch

2x 109025

2x 109088

not in computer ML 08/08/30 (4)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank: 56" long

Machine holes as per Folio FA295 and Dwg D3173

Identify as D3173-1

ML 08/08/30 (4)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

M.A 08/08/30 (4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/08/30 (4)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ML 08/08/30 (4)

POSITIVE RECALL

EFFECTIVE *[Signature]* AUTH *[Signature]*RELEASED *[Signature]* DATE *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 11:24:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41631

Part Number: D3173041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

N.A

08/08/30

7.0 ~~QC5~~ SECOND CHECK



Comment: SECOND CHECK

S 08/09/10

(4)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill Ø0.316" holes as per Dwg D3173
C'sink holes as per Dwg D3173

FF 08/09/11

(4)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/11

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M. 08/09/16

(4X)

11.0 D3178041 Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Nut Plate
Pick K10017. Install Nut Plate as per Dwg D3173. D3178-041 is included in K10017 BOM.
Pick:

Qty	Part Number	Description	Batch
2	D3178-041	Nut Plate	B24095 B

FF 08/09/19

(4)

12.0 MS20601AD4W4 Rivet





Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Rivet
Pick:

Qty	Part Number	Description	Batch
8	MS20601AD4W4	Rivet	19278

FF 08/09/19

(4)

W/O: 41631		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/9/04	#7.0	Permit Issue QCS # ESTIMATE # 10407		08/09/05			 08/09/07

Part No: D3173-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 11:24:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41631

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/12 (24)

14.0

POWDER COATING

POWDER COATING



M108523



(4X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3
Ensure Nut Plate thread is covered.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12⁰⁰
322^{0 F}
12³⁰

m.f 08/09/19

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

cf 08/09/22 (2)

16.0

D3175041

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Mounting Lug

Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

Pick:

Qty	Part Number	Description	Batch
2	D3175-041	Mtg Lug	M25025

510

17.0

AN35A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN3-5A	Bolt	M100188

SP

18.0

AN523A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN5-23A	Bolt	M19278

M19278

8/9/19

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 11:24:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41631

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD10

Washer

M104625

M105402

50

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

AN960JD516

Washer

M108672

50

21.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21042L5

Nut

M108161

8/9/19

50

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble per Dwg D3173.

Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

FF 08/09/19

08/09/22

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/22

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as D3173-041 and Pack with D130-701-041

Location: 302

8/9/23

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41631

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3173	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RELEASED
03.01.20 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44631*

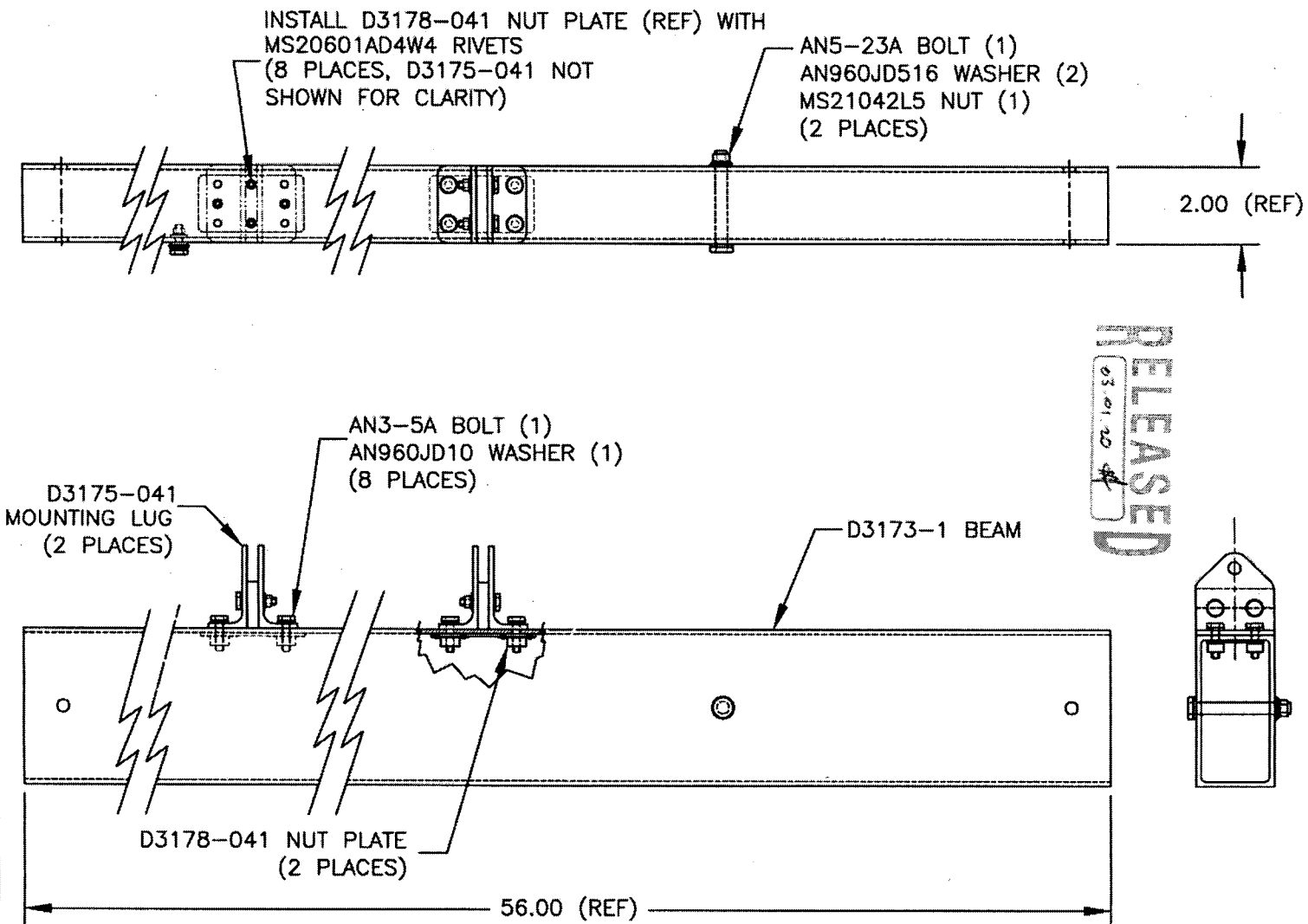
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3173	REV. B
DATE 03.01.07	TITLE BEAM ASSEMBLY	SHEET 2 OF 3	SCALE 1:4



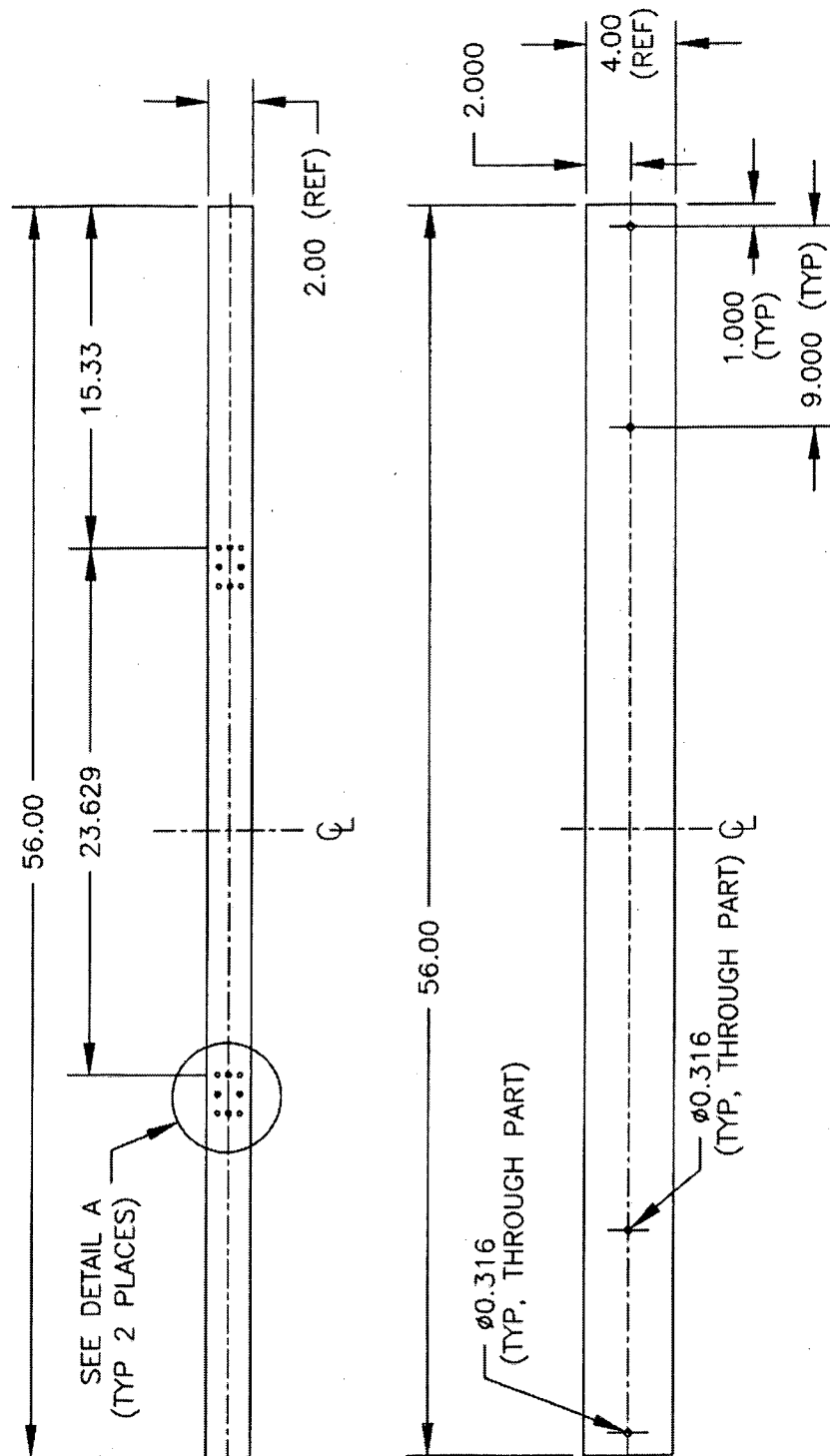
D3173-041 BEAM ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. 44637



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3173	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE 1:8

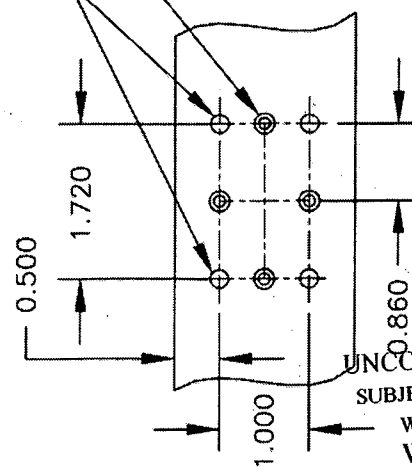
D3173-1 BEAM



RELEASED
03-01-20

- DRILL #30 (Ø0.129)
 C'SINK Ø0.235x100"
 (TYP. 8 PLACES TOTAL,
 DRILL THIS SURFACE ONLY)

DETAIL A
SCALE 1:2



0980 SHOP COPY
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NO 41651

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